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Title:

METHOD OF FORMING AN ISOLATION LAYER IN A SEMICONDUCTOR DEVICE

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METHOD OF FORMING AN ISOLATION LAYER IN A SEMICONDUCTOR DEVICES

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BACKGROUND OF THE INVENTION

Field of the Invention

The present invention relates to a method of forming an isolation layer in the semiconductor device, and more particularly, to a method of forming an
10 isolation layer in the semiconductor device, capable of simultaneously preventing concentration of an electric field on the top corner of a trench and formation of a moat.

Background of the Related Art

15 In all the processes of manufacturing semiconductor devices, an isolation layer is formed in an isolation region in order to electrically isolate respective devices formed at the semiconductor substrate. In the prior art, the isolation layer is formed by LOCOS (local oxidation) process. At the degree of integration in the device, however, the isolation layer has recently been
20 formed by means of a process of etching the semiconductor substrate by a given depth to form the trench and the trench is buried with an insulating material. The isolation layer formed thus is called a trench type isolation layer.

The trench type isolation layer is formed by forming a pad oxide film

and a pad nitride film through which the isolation region is exposed on a semiconductor substrate, etching the semiconductor substrate in the isolation region and then burying an insulating material layer. Thus, even though the pad nitride film and the pad oxide film are removed, the insulating material layer buried between the pad nitride film and the pad oxide film remains intact. Due to this, the isolation layer consisting of the insulating material layer has a shape in which the isolation layer is buried into the trench and a shape in which the width of the isolation layer is narrow than that of the isolation region and the upper side thereof is projected higher than the surface of the semiconductor substrate.

Even in the process of manufacturing flash memory cells, the isolation layer is formed using the trench type isolation layer. At this time, the isolation layer is formed by means of SAFG (self aligned floating gate) process by which a polysilicon layer for a floating gate is isolated by a projection of the trench type isolation layer. If the polysilicon layer for the floating gate is isolated by the projection of the trench type isolation layer, a region where the floating gate will be formed can be secured by maximum since the distance between the floating gates can be more narrowed. Therefore, the coupling ratio of the floating gate could be increased.

In the above, one of the most important things is to prevent that the tunnel oxide film or the gate oxide film is thinly formed, while simultaneously preventing concentration of the electric field and formation of a moat, using the top corner slope of the trench. There is a problem that the top corner of the trench may not be formed locally within the wafer since the process

condition of the etch process for forming the isolation layer is varied.

SUMMARY OF THE INVENTION

Accordingly, the present invention is contrived to substantially obviate
5 one or more problems due to limitations and disadvantages of the related art,
and an object of the present invention is to provide a method of forming an
isolation layer in the semiconductor device, capable of simultaneously
preventing concentration of the electric field and formation of a moat, by
forming the isolating film by means of a method in which a method of forming
10 a V type trench at the isolation region, implanting ions capable of accelerating
oxidization action into the center portion of the V type trench, implementing
an oxidization process to form an insulating film consisting of an oxide film at
the isolation region, and then completely burying the trench with an insulating
material, using the LOCOS method, and a method of forming a trench type
15 isolation layer, are applied together, whereby the top corner of the trench is
formed with inclination.

In a preferred embodiment, the method of forming the isolation layer in
the semiconductor devices according to the present invention is characterized
in that it comprises the steps of sequentially forming a tunnel oxide film and a
20 pad nitride film on a semiconductor substrate and then forming an aperture
through which an isolation region of the semiconductor substrate is exposed,
forming a V type trench at the isolation region, forming an insulating film
spacer at the sidewall of the pad nitride film in the aperture, forming an ion
implantation layer for accelerating oxidization at the bottom of the V type

trench that is exposed through the aperture, forming a first insulating film at the V type trench by means of an oxidization process, burying the aperture on the first insulating film with a second insulating film, and removing the pad nitride film and the pad oxide film.

5 In the above, a tilt angle of the V type trench is $25 \sim 45^\circ$.

The ion implantation layer is formed by implanting arsenic (As). At this time, arsenic (As) is implanted with energy of $15 \sim 50\text{keV}$ and the dose of implantation of As is $1\text{E}14 \sim 1\text{E}16\text{cm}^{-2}$.

10 The oxidization process is performed at a temperature of $800 \sim 950^\circ\text{C}$ by setting an oxidization target thickness of $300 \sim 1000\text{\AA}$, whereby the first insulating film is formed in thickness of $1500 \sim 4000\text{\AA}$ by means of the ion implantation layer for accelerating oxidization.

The second insulating film is formed using a HDP oxide film and is formed in thickness of $2000 \sim 5000\text{\AA}$.

15 Additional advantages, objects, and features of the invention will be set forth in part in the description which follows and in part will become apparent to those having ordinary skill in the art upon examination of the following or may be learned from practice of the invention. The objectives and other advantages of the invention may be realized and attained by the structure
20 particularly pointed out in the written description and claims hereof as well as the appended drawings.

In another aspect of the present invention, it is to be understood that both the foregoing general description and the following detailed description of the present invention are exemplary and explanatory and are intended to

provide further explanation of the invention as claimed.

BRIEF DESCRIPTION OF THE DRAWINGS

5 The above and other objects, features and advantages of the present invention will be apparent from the following detailed description of the preferred embodiments of the invention in conjunction with the accompanying drawings, in which:

FIG. 1A through FIG. 1L are cross-sectional views of semiconductor devices for explaining a method of forming an isolation layer in the devices.

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DETAILED DESCRIPTION OF THE PREFERRED EMBODIMENT

Reference will now be made in detail to the preferred embodiments of the present invention, examples of which are illustrated in the accompanying drawings, in which like reference numerals are used to identify the same or similar parts.

A method of forming an isolation layer in the semiconductor devices will be now described in detail by reference to FIG. 1A through FIG. 1L.

20 Referring now to FIG. 1A, a pad oxide film **102** and a pad nitride film **103** are sequentially formed on a semiconductor substrate **101**, in order to prohibit generation of crystal defects on the entire structure and implement surface processing.

The pad oxide film **102** is formed in thickness of 50 ~ 70Å by means of dry oxidization mode or wet oxidization mode at a temperature of 750 ~ 900°C.

Further, the pad nitride film **103** may be formed in thickness of 700 ~ 2000Å by means of LP-CVD method. At this time, the thickness of the pad nitride film **103** is not limited to the above value. Instead, the thickness of the pad nitride film **103** may be determined depending on the process condition so that
5 the top of the isolation layer is protruded higher by maximum than the surface of the semiconductor substrate **101** when the chemical mechanical polishing process is implemented as the last process to form the isolation layer and the pad nitride film is the removed.

Meanwhile, cleaning process may be performed before the pad oxide
10 film **102** is formed. At this time, the cleaning process may be implemented sequentially using hydrofluoric acid (DHF) where $\text{H}_2\text{O}:\text{HF}$ is mixed at the ratio of 50:1 ~ 100:1, and a SC-1 ($\text{NH}_4\text{OH}/\text{H}_2\text{O}_2/\text{H}_2\text{O}$) solution, or sequentially using a BOE (buffered oxide etchant) in which a mixed solution where $\text{NH}_4\text{F}:\text{HF}$ is mixed at the ratio of 4:1 ~ 7:1 is diluted into H_2O at the ratio of
15 1:100 ~ 1:300, and a SC-1 ($\text{NH}_4\text{OH}/\text{H}_2\text{O}_2/\text{H}_2\text{O}$) solution.

Referring now to FIG. 1B, the pad nitride film **103** and the pad oxide film **102** are sequentially etched by means of etch process using the isolation mask, thus forming an aperture **104a** through which the isolation region of the semiconductor substrate **101** is exposed. Thereby, the pad oxide film **102** and
20 the pad nitride film **103** through which the isolation region of the semiconductor substrate **101** is exposed are formed to be a stack structure.

Next, the semiconductor substrate **101** of the isolation region, which is exposed through the aperture **104a**, is etched to form a V type trench **104**. At this time, the etched portion of the pad nitride film **103** is formed to be vertical

and the sidewalls of the V type trench **104** are formed to have a tilt angle of 25 ~ 45°.

By reference to FIG. 1C, in order to form an insulating film spacer at the sides of the aperture **104a** in the pad nitride film **103**, an insulating material layer **105a** is formed on the entire structure. At this time, the insulating material layer **105a** is formed to have an adequate thickness considering the thickness of the insulating film spacer to be formed at the pad nitride film **103**. Preferably, the insulating material layer **105a** is formed in thickness of 300 ~ 1000Å. Meanwhile, the insulating material layer **105a** may be formed using nitride like the pad nitride film **103**.

Referring to FIG. 1D, the insulating material layer (**105a** in FIG. 1C) remains only at the sidewalls of the aperture **104a** in the pad nitride film **103**, by means of blanket etch process, thus forming the insulating film spacer **105** at the sidewall of the pad nitride film **103**. While the width of the aperture **104a** is narrowed by the insulating film spacer **105**, only a deep portion at the center of the V type trench **104** is exposed.

By reference to FIG. 1E, in order to accelerate oxidization in a subsequent oxidization process, ions for accelerating oxidization are implanted into the deep portion of the center of the V type trench **104** exposed through the aperture **104a**. Thereby, an ion implantation layer **106** is formed at the deep portion of the center of the V type trench **104**.

In the above, the ion implanted into the deep portion of the center of the V type trench **104** may include arsenic (As). The dose of implantation is $1\text{E}14 \sim 1\text{E}16\text{cm}^{-2}$. Meanwhile, when the ion is implanted by ion implantation

process, the ion is implanted using the energy of 15 ~ 50keV.

Referring to FIG. 1F, in order to remove a native oxide film (not shown) formed on the surface of the V type trench **104**, the cleaning process is performed and a first insulating film **107** is then formed at the center of the V type trench (**104** in FIG. 1E) exposed through the aperture **104a**. At this time, the first insulating film **107** may be formed using an oxide film and the oxide film is formed by the oxidization process of a wet or dry oxidization mode.

In the above, the oxidization process is performed at a temperature of 800 ~ 950°C by setting up an oxidization target thickness to be 300 ~ 1000Å. At this time, as the ion implantation layer (**106** in FIG. 1E) for accelerating oxidization is formed at the center of the V type trench (**104** in FIG. 1E) exposed through the aperture **104a**, the oxidization process rapidly proceeds to form a first insulating film **107** of 1500 ~ 4000Å in thickness.

By reference to FIG. 1G, after a second insulating film is formed on the entire structure, the second insulating film on the pad nitride film **103** is removed. At this time, the second insulating film on the pad nitride film **103** may be removed by means of chemical mechanical polishing using the pad nitride film **103** as a polishing stop layer.

Meanwhile, after the pad nitride film **103** is completely removed in a subsequent process, the height of the isolation layer **109** that protrudes upwardly from the surface of the semiconductor substrate **101** may be determined depending on the thickness of the pad nitride film **103** remaining after the chemical mechanical polishing. Therefore, if the top of the pad nitride film **103** is excessively removed as the second insulating film on the

pad nitride film 103 is removed to expose the pad nitride film 103 during the chemical mechanical polishing process, the height of the projection of the isolation layer 109 that is protruded higher than the surface of the semiconductor substrate is lowered. This affects the height of the polysilicon layer for the floating gate to be formed in a subsequent process. Accordingly,
5 it is preferred that the process condition of the chemical mechanical polishing process is controlled so that the projected top of the isolation layer 109 is not lowered.

Thereby, the isolation layer 109 having a second insulating film 108
10 remaining only at the aperture 104a on a first insulating film 107 and consisting of the first and second insulating films 107 and 108, is formed.

In the above, the second insulating film 108 is formed using a HDP (high density plasma) oxide film. Further, the second insulating film 108 is formed in thickness of 2000 ~ 5000Å so that the aperture 104 as well as the
15 trench (104 in FIG. 1E) is completely buried when the second insulating film 108 is formed on the entire structure.

Referring to FIG. 1H, the pad nitride film (103 in FIG. 1G) is removed. At this time, the pad nitride film is removed using phosphoric acid (H_3PO_4). Thereby, the projection 109a of the isolation layer 109 is exposed and the
20 surface of the pad oxide film 102 is exposed in the device formation region.

Through the above processes, the isolation layer of the present invention is formed. Thereafter, if a flash memory cell is to be manufactured, the pad nitride film and the pad oxide film are removed, and the tunnel oxide film, the floating gate the dielectric film and the control gate are then formed on the

semiconductor substrate. This manufacture process will be below described in short.

By reference to FIG. 1I, the pad oxide film (**102** in FIG. 1H) remaining on the semiconductor substrate **101** is removed. A screen oxide film **110** having a thickness of 50 ~ 150Å is then formed on the semiconductor substrate **101** of the active region where devices will be formed, by means of wet or dry oxidization process at a temperature of 750 ~ 900°C. After the screen oxide film **110** is formed, a well (not shown) is formed in the semiconductor substrate **101** of the active region through the ion implantation process. Also, a threshold voltage control layer (not shown) for controlling the threshold voltage of the device such as the transistor or the flash memory cell is formed at a given depth of the semiconductor substrate **101**.

In the above, the pad oxide film (**102** in FIG. 1H) is removed sequentially using hydrofluoric acid (DHF) where H₂O:HF is mixed at the ratio of 50:1 ~ 100:1, and a SC-1 (NH₄OH/H₂O₂/H₂O) solution.

At this time, in the process of removing the pad oxide film (**102** in FIG. 1H), the projection **109a** of the isolation layer **109** is also etched by a given thickness. The top of the projection **109a** of the isolation layer **109** is wider than the bottom thereof. In the process of removing the pad oxide film (**102** in FIG. 1H), however, the top of the projection **109a** is more etched than the bottom thereof, so that the widths of the top and bottom of the projection **109a** become similar.

Referring to FIG. 1J, the screen oxide film (**110** in FIG. 1I) is removed. A tunnel oxide film **111** and a first polysilicon layer **112** for a floating gate are

then sequentially formed on the entire structure. Thereafter, the chemical mechanical polishing process is performed until the surface of the projection **109a** of the isolation layer **109** is exposed, thus isolating the first polysilicon layer **112**. Thereby, the first polysilicon layer **112** is isolated by the isolation layer **109**.

In the above, the screen oxide film (**110** in FIG. 1I) is removed sequentially using hydrofluoric acid (DHF) where $\text{H}_2\text{O}:\text{HF}$ is mixed at the ratio of 50:1 ~ 100:1, and a SC-1 ($\text{NH}_4\text{OH}/\text{H}_2\text{O}_2/\text{H}_2\text{O}$) solution.

Meanwhile, the tunnel oxide film **111** is formed by the wet oxidization process at a temperature of 750 ~ 800°C. Next, the tunnel oxide film **111** is annealed under nitrogen atmosphere at a temperature of 900 ~ 910°C for 20 ~ 30 minutes, thus minimizing the interfacial defect intensity of the semiconductor substrate **101** and the tunnel oxide film **111**. Further, the first polysilicon layer **112** for forming the floating gate is formed using a polysilicon layer into which an impurity of a high concentration is doped. Explaining in more detail, the first polysilicon layer **112** is formed by means of a LP-CVD (low pressure chemical vapor deposition) method using one of SiH_4 or Si_2H_6 and PH_3 gas as a source so that an impurity of $1.5\text{E}20 \sim 3.0\text{E}20$ atoms/cc is doped. Further, the first polysilicon layer **112** is formed at a temperature of 580 ~ 620°C under a low pressure condition of 0.1 ~ 3Torr in order to minimize the grain size so that the electric field is not concentrated at one place. The first polysilicon layer **112** is formed in thickness of 800 ~ 2000Å.

Further, the chemical mechanical polishing process is implemented so

that the first polysilicon layer **112** can be completely isolated by the projection **109a** using the projection **109a** of the isolation layer **109** as an etch stop layer. Preferably, the chemical mechanical polishing process is performed so that the first polysilicon layer **112** remains in thickness of 800 ~ 1400Å.

5 Referring to FIG. 1K, the projection (**109a** in FIG. 1J) of the isolation layer **109**) that is exposed between the first polysilicon layers **112** is removed using HF or BOE (buffered oxide etchant). Thereby, the lateral sides of the first polysilicon layer **112** for the floating gate, which contacts the projection **109a** in FIG. 1J) of the isolation layer **109**, is exposed, so that the coupling
10 ratio of the floating gate could be increased.

By reference to FIG. 1L, a dielectric film **113**, a third silicon layer **114** for a control gate and a silicide layer **115** are sequentially formed on the entire structure.

In the above, the dielectric film **113** may have an ONO structure on
15 which a lower oxide film (SiO_2), a silicon nitride film (Si_3N_4) and an upper oxide film (SiO_2) are sequentially stacked. Also, the silicide layer **115** may be formed using a tungsten silicide (WSi_x) layer.

At this time, lower and upper oxide films of the ONO dielectric film may be formed using a HTO (hot temperature oxide) film, which is formed
20 using DCS (SiH_2Cl_2) and N_2O gas having a good internal pressure and a good TDDB (time dependent dielectric breakdown) characteristic gas as a source gas. Further, the silicon nitride film is formed by means of the LP-CVD method using DCS (SiH_2Cl_2) and NH_3 gas at a temperature of 650 ~ 800°C and at a low pressure of 1 ~ 3Torr. After the dielectric film **113** of the ONO

structure is formed, a steam anneal process may be performed in a wet oxidization mode at a temperature of $750 \sim 800^{\circ}\text{C}$ in order to improve the interfacial characteristic between the films. The steam anneal process is performed so that an oxidization target thickness is $150 \sim 300\text{\AA}$ on bare
5 Silicon wafer (monitoring wafer) base.

Meanwhile, the lower oxide film, the silicon nitride film and the upper nitride film are deposited in thickness corresponding to their device characteristics, wherein respective processes of depositing the oxides proceed with no time delay in order to prevent contamination of them with the native
10 oxide film or impurities. At this time, it is preferred that the lower oxide film is formed in thickness of $35 \sim 60\text{\AA}$, the silicon nitride film is formed in thickness of $50 \sim 65\text{\AA}$ and the upper oxide film is formed in thickness of $35 \sim 60\text{\AA}$.

Thereafter, though not shown in the drawings, an anti-reflecting film
15 (not shown) consisting of SiO_xN_y or Si_3N_4 is formed on the silicide layer **115**. The anti-reflecting film, the silicide layer **115**, the third polysilicon layer **114** and the dielectric film **113** are then patterned by means of the etch process using the control gate mask, thus forming a control gate **116** consisting of the third polysilicon layer **114** and the silicide layer **115**. Next, the first
20 polysilicon layer **112** is patterned by means of the self-aligned etch process using the patterned anti-reflecting film, thus forming the floating gate consisting of the first polysilicon layer **112**. Thereby, the flash memory cell is manufactured.

As described above, the method of manufacturing the flash memory cell according to the present invention can have the following advantages.

First, only one isolation mask for defining an isolation region is used in the process of forming the isolation layer. Accordingly, the degree of
5 difficulty in the process can be lowered and the process cost could be reduced.

Second, the top corner of the trench is formed to have a tilt angle of a low angle. It is thus possible to prevent the tunnel oxide film or the gate oxide film from being thinly formed in a subsequent process and prohibit generation of a moat.

10 Third, the polysilicon layer for the floating gate is isolated by means of the projection of the isolation layer and the projection is then removed to increase the coupling ratio. Thus, the critical dimension can be minimized to form a uniform floating gate and variation in the coupling ratio could be prevented.

15 Fourth, the floating gate is uniformly formed in order to make constant the coupling ratio. It is thus possible to improve the device characteristics.

Fifth, the process condition such as the thickness of the pad nitride film, the height and width of the projection in the isolation layer and the polishing thickness of the chemical mechanical polishing process is easily controlled.
20 Accordingly, the process margin such as controlling the surface area of the floating gate can be secured.

Sixth, the process margin can be secured and a high-integration flash memory cell of over 0.13 μ m level could be also easily manufactured, with the existing equipments and processes without using complex processes and

expensive equipments.

The forgoing embodiments are merely exemplary and are not to be construed as limiting the present invention. The present teachings can be readily applied to other types of apparatuses. The description of the present
5 invention is intended to be illustrative, and not to limit the scope of the claims. Many alternatives, modifications, and variations will be apparent to those skilled in the art.